Work Order I September-11-13 11				*106	3669*							Page 1	
Item ID: D40 Revision ID:	62-041		A	Accept	*N900	040	100	)*	Setup	Start	*N	S1* +	=
Item Name: Tank	Support Assembly	•								Stop	*N:	S2*	
Start Date: 9/11	/13 Start Qty	: 1.00	*1*		Cust Item 1	D:							
Required Date: 9/11	/13 Req'd Qt	y: 1.00	*1*		Customer:								
Reference:		•	•										
Approvals: Pro	ocess Plan: ML	5	Date: 13 -09-13	Tooling:	D	ate:		]	Run	Start	17	R1*	
QC	<b>:</b>		Date:	<b>SPC (Y/N):</b>	D	ate:				Stop	*N	R2*	2
Sequence ID/ Work Center ID	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Re	•	Reject Number	Insp. Stamp	_
Draw Nbr	Revision Nbr					14,111							
D4062	D								_				
100	,	<del></del>		0.00				*					
*100*								1		0		Ae	
Waterjet		Memo		0.00				•		`		13.09.2	
FROW CNC Waterjet		CUT BLAN	IK AS PER FILE D4062-1_B	BLANK									
102	QC2- Inspec	t parts off m	nachine FAI/FAIB	0.00									
*102*			<b>&gt;</b> .					1		O		Ao	`
QC		Memo		0.00						<b>U</b>		13.09.2	>
Quality Control													
												•	
105 .				0.00									
*105*					1	11		,		/=-			
HAAS I		Memo		0.00	on B	11/19	,			<u> </u>	<del></del>	·	
HAAS CNC vertical mach		MILL AS P DWG REV: FOLIO REV										<b>(</b>	

											DQA:	Dat	e:	
NCR:	Yes	/ No				WORK ORDER NON-C	100	<b>VFORN</b>	ANCE / UPI	DATE		···		-
									•		QA Closed:	Dat	e:	•
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
WOIK OIGH	-			<del> </del>		Rework	1		Skid-tube	Crosstube	1	Water Jet	En	gineering
Part I	۷o.					Scrap		ľ	Machining	Small Fab	Pro	d. Eng. Coor.		Quality
						Use-as-is			noforming	Finishing	Rec/Sto	re/Packaging	_	Other
NCR I	No.	· · · · · · · · · · · · · · · · · · ·				Work Order Update	]		Large Fab	Composite	]	Supplier		
Root					Descri	ption of work order update		initial	Act	tion	Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	• •	QC Inspector
Doc/Data	Ш					•								
Equip/Tooling	Ш													
Operator	Щ													
Material	Ц						l							
Setup	Ш											E		
Other	Ш			-			1		-					
Process	Ш													
Supplier	Ш		1 .											
Training	Ш		ļ											
Unapproved			<u> </u>	<u> </u>					,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,			<u></u>		
							AUI	T CATE	GORY	······································		· #***		
Landi					_	General		7		_	7	r		
	$\mathbf{L}$	Bending			<u> </u>	Bend	$\vdash$	Grain		ļ	Ovalized	<u> </u>		sure/Forced
	$\vdash$		ot Conce	ntric to O	/s	BOM/Route		Hardwa		<u> </u>	Over/Under	- +		perature/Cure
		Cracks			lacksquare	Broken/Damaged	<u>_</u>	-1	on Incomplete	<u> </u>	Part Incorre	-	Wel	
		Crushed/	'Crimped		<u> </u>	Burrs	<u></u>	4	ions Incomplete/	Unclear	Part Lost/M	issing	Wro	ng Stock Pulled
		Cuffs				Contamination	<u>_</u>	Mainte		<u></u>	Part Moved			
		Heat Tre				Countersink	$\perp$	Mislabe		<u></u>	Positioned \		_	
	$\vdash$	Inspectio		Tube		Cut Too Short	_	Misread	i		Power Loss/	Surge [	Othe	er
		Ripples in	n Bend			Drill Holes		Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde				*106	6669*				Page 2
Item ID: Revision ID:	D4062-041			Accept	*N90004	.0100	)* s	etup Start Stop	10.21
Item Name:	Tank Suppor	t Assembly						Stop	*NS2*
Start Date: Required Date: Reference:	9/11/13 9/11/13	Start Qty: , 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:				
Approvals:	Process Pl	an:	Date:	Tooling:	Date:		F	Run Start	*NR1*
					Date:			Stop	*NR2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	, ,	ol # Plan Code	Accept Qty		Reject Insp. Number Stamp
-106		QC2- Inspect parts off m	nachine FAI/FAIB	0.00	13/11/19				
*106* QC Quality Control	211	Memo		0.00				B	
Manual Mail	<u>-</u>					,			
130		QC8- Inspect parts - seco	ond check	0.00	13/11/21		1		08
*130* QC Quality Control		Memo		0.00	, ,			<u> </u>	\&&
140		Identify as per dwg & St	ock Location: WM	.BO3 0.00			_	,	<i>(i)</i>
*140* Packaging		Memo		0.00			#_		13.11.2.
Packaging									
	-		·						CANA.

NCR: Y	es/	/ No				<b>WORK ORDER NON-C</b>	O	NFORM	ANCE / UPI	DATE			_		7
						<u></u>					(	QA Closed:	D	ate:	
Work Orde	sė.					DISPOSITION				AGAINST D	DEP	ARTMENT	PROCESS		
Part N	-					Rework Scrap Use-as-is		ľ	Skid-tube Machining noforming	Crosstube Small Fab Finishing			Water Je d. Eng. Coor e/Packagin	· $\square$	Engineering Quality Other
NCR I	No.					Work Order Update	]		Large Fab	Composite			Supplie	_	
Root					Descri	ption of work order update	Į į	nitial	Act	ion		Sign &			
Cause	$\square$	Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desci	ription	1	Date	Verificati	on	QC Inspector
Doc/Data	Ш														
Equip/Tooling			1				1				1		•	i	
Operator											١				
Material							1								
Setup												'			
Other	Щ			1 1											
Process	Щ														
Supplier															
Training	Ш														
Unapproved			<u> </u>				<u> </u>								
							AUL	T CATE	GORY						<del></del>
Landi	_				_	General	_	1		_	_			_	
	$\vdash$	Bending	_		. L	Bend	<u> </u>	Grain		-	—	Ovalized		$\vdash$	Pressure/Forced
		Centre N	ot Concei	ntric to C	<sup>)/S</sup>  _	BOM/Route	<u> </u>	Hardwa		-	→	Over/Under		-	Temperature/Cure
	-	Cracks			<u> </u>	Broken/Damaged	<u> </u>	4 '	on Incomplete		-4	Part Incorred		-	Weld
	Ш	Crushed/	Crimped		<u> </u>	Burrs	$\vdash$	4	ions Incomplete/	Jnclear		Part Lost/Mi	ssing		Wrong Stock Pulled
	<u> </u>	Cuffs			<u> </u>	Contamination	$\vdash$	Mainte		-		Part Moved			
		Heat Trea			<u> </u>	Countersink	<u></u>	Mislabe		-	-	Positioned V	-	_	
İ	$\vdash$	Inspectio	-	Tube	ļ	Cut Too Short	$\vdash$	Misread	I	L		Power Loss/	Surge		Other
	_	Ripples in			<u> </u>	Drill Holes	$\vdash$	Offset			-	·			
1	1	Torque V	Vaves in E	Extrusion	1	Drawing	1	Out of C	Calibration						

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish Folio

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Work Orde				*106	3669*					]	Page 3
Item ID: Revision ID: Item Name:	D4062-04	rt Assembly		Accept	*N900	<b>040</b>	100	* Se	etup Start Stop	14.7	•
Start Date: Required Date: Reference:	9/11/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:				14(1)	:
Approvals:	Process P		Date:	Tooling: SPC (Y/N):		ate: ate:		R	un Start Stop	"NH"	1 * ) *
Sequence ID/ Work Center II	D	Operation Description QC21- Final Inspection	- Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Ins Number Sta	•
*150*		Memo		0.00				-471/	1 41771	15/11/45	

Quality Control

13/11/25 · -me (3-11-25

											DQA	ı: Da	ate:	
NCR:	Yes	/ No				WORK ORDER NON-O		NFORM	ANCE / UPI	DATE		***************************************	•	,
											QA Closed	d: Da	ate:	,
Work Orde	or.					DISPOSITION				AGAINST DE	EPARTMEN	T/PROCESS		
WOIK OIU	er. 	····				Rework	1		Skid-tube	Crosstube	1	Water Jet		Engineering
Part I	۷o.					Scrap		ſ	Machining	Small Fab	Pr	od. Eng. Coor.		Quality
NCD I	Ma.					Use-as-is	-	1	noforming Large Fab	Finishing Composite	-	ore/Packaging Supplier	_	Other
NCR I	NO					Work Order Update	]		raige rau	Composite	_	Supplier		
Root					Descri	otion of work order update		Initial	Act	tion	Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ct	nief Eng	Descr	ription	Date	Verification	on	QC Inspector
Doc/Data	Ш													
Equip/Tooling	Ш		1											
Operator			ļ											
Material			1											
Setup														
Other														
Process							1							
Supplier											ł			
Training											ŀ			
Unapproved									l					
						F	AUI	LT CATE	GORY					
Landi	ing G	ear				General		_			_			-
		Bending				Bend	L	Grain			Ovalized			Pressure/Forced
		Centre N	ot Conce	ntric to O	/s	BOM/Route		Hardwa	re	L.	Over/Unde	er tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on incomplete		Part Incom	ect		Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/l	Unclear	Part Lost/I	Missing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Move	d		
		Heat Tre	at			Countersink		Mislabe	led		Positioned	Wrong	_	_
		Inspectio	n Strip in	1 Tube		Cut Too Short		Misread	5		Power Los	s/Surge		Other
		Ripples ii	n Bend			Drill Holes		Offset		_				

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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**Picklist Print** 

September-11-13 11:18:01 AM

Page 1

Work Order ID:

106669

Parent Item:

D4062-041

Parent Item Name:

Tank Support Assembly

**Start Date: 9/11/13** 

Required Date: 9/11/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP REV:A NEW ISSUE 11-11-23 JLM VERIFIED BY:DD 03-08 JLM VERIFIED BY:DD IPP REV:C AS PER RE

IPP REV.C AS PER REV D 13-07-16 II M VERIFIED BY:DD

123290

IPP REV:B AS PER REV C 12-

** <u>. *</u>	05-06 JEIVI VEICI	110001.00	11 1 1(1)	V.C MOTER.	ICE V 15 15-07-1	O JUNI VUI	CIL TED DI.L	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,					
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB1.250 UHMWB 1.250 BLACK		Purchased	No				sf	95.0000		<del>-3.83684</del> .	21-	4 1	3.09.23

Location MAT019

Loc Qty 95

95

Loc Code

NCR: Ye	es	/ No				<b>WORK ORDER NON-</b>	CO	NFORM	MANCE / UPI	DATE			,
											QA Closed:	Da	te:
Work Orde	r: _					DISPOSITION	7			AGAINST DE	PARTMENT,	•	
Part N NCR N	-					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube  Machining noforming  Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Quality Other
Root					-	ption of work order update	- 1	Initial	Act		Sign &		
Cause	_	Date	Step	Qty	(	or Non-conformance	CI	nief Eng	Descr	ription	Date	Verificatio	n QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved							FAU	LT CATE	GORY				
Landin	ng G	iear				General							
		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	Crimped at n Strip in n Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	ion Incomplete tions Incomplete/U enance eled d	Jnclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned \( \) Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	⊢	Torque V	Vaves in E	Extrusio	n	Drawing		Out of 0	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

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DART AEROSPACE LTD	Work Order:	106669
Description: Lower Tank Support	Part Number:	D4062-1
Inspection Dwg: D4062 Rev: & D OFS		Page 1 of 1

## 13/09/17 FIRST ARTICLE INSPECTION CHECKLIST

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension		Dimension	7,000,0	,	Inspection	Gomments
1.00 ~	+/-0.030	1.012			Ven	41-06
<b>-</b> 0.13	+/-0.030	.148			1)	
<b>~2.00</b>	+/-0.030	2.004			, ,	
- 1.00 1,25	+/-0.030	1.248			"	
<b>~</b> 0.35 ⋅	÷/-0.039	.350			/'	
✓ R0.25	+/-0.030	R.250			R-6-	1
<b>~</b> 0.38	+/-0.030	.370			Ven	71-06
<b>₩</b> 0.38	+/-0.030	.345			10.	
√ 1.38	+/-0.030	1.383			,,	
∽ R0.25	+/-0.030	R250			R-6-	
<b>√31.38</b>	+/-0.030	31.380	_		Vertase	11-08
<i>⊷</i> 28.30	+/-0.030	28.300				
√ 26.30	+/-0.030	26.300				i
<b>∠20.83</b>	+/-0.030	20.830				f.
<b>~15.51</b>	+/-0.030	15.570				
<b>∟</b> 10.19	+/-0.030	10.190				
<b>∠</b> 5.07	+/-0.030	5,070			Vers	MLDL
<b>►3.07</b>	+/-0.030	3.070				
v31,25°	1/0,030	31.250			M tox	76-68
-0, 38	*/-0,030	.370			Vem	41-06
20,23 74pls						

Measured by:	Audited by: 15.0	Preliminary Approval:	
Date: 13/11/19	Date: /3 11 2	Date:	

	Change	Revised by	Approved
A 12.02.0	1 New Issue	KJ	
B 12.05.1	5 Dimensions updated per Dwg Rev C	KJ 🕠	LA
C 12.06.0	8 : Part description corrected	KJ 4XT	/X/

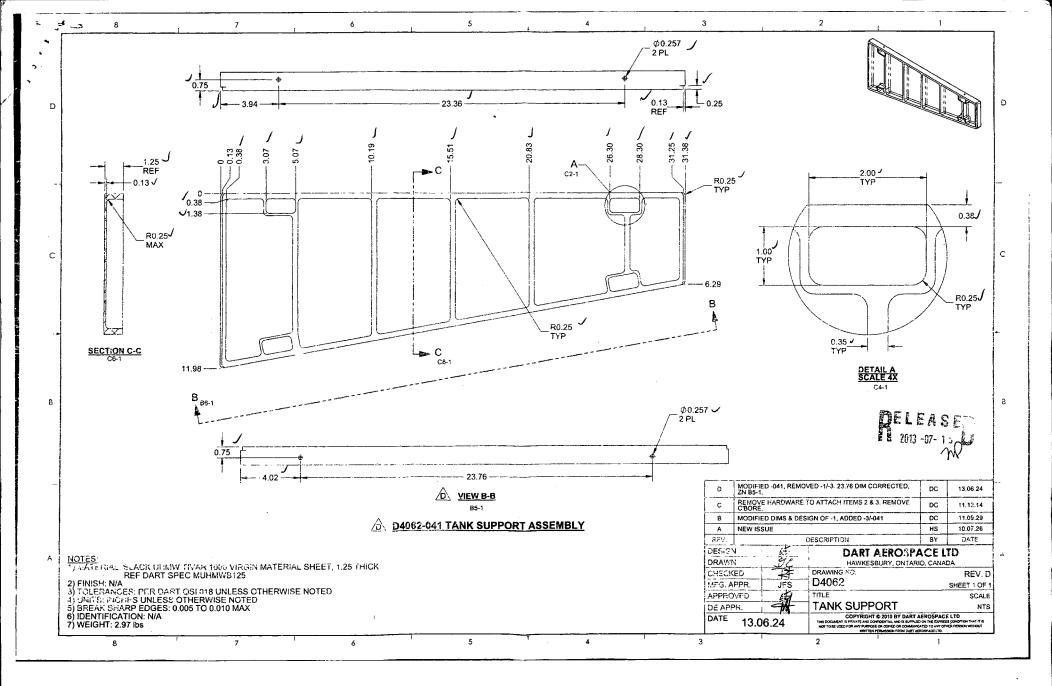
DART AEROSPACE LTD	Work Order: 10 666 9		
Description: Lower	Part Number: D4062-1		
Inspection Dwg: D4062 Rev: D	Page 1 of 1		

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0,15	± 0,030					
3 <b>4</b> 4	±0,030					
23,36	± 0,030					
0,25	± 0,030	.255			Vem	not
0.13	±0,030	.115			1)	
0.25	t=0,030					
402	top30					
23	10,030					
					<u> </u>	
					<u> </u>	

Measured by:	me	Audited by:	b =		Preliminary Approval:	
Date:	13/11/19	Date:	13/11/21	88	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	L



106669 MJ